

Date: Thursday, 2/22/2007 2:57:20 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB ASSEMBLY
Job Number	: 30808		
Estimate Number	: 10194		
P.O. Number	: N/A	Part Number	: D2174041
This Issue	: 2/22/2007	Drawing Number	: D2174 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 29225	Material	: N/A
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	: <u>JA 07.02.23</u>	Qty:	21
Comment	: Est: D04/06.10 Reformat; Changed Step 2 KJ/JLM	Um:	25
	Est Rev:E As per Rev E 06-11-22 JLM	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D21741	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)
Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	B30870

2.0	D21751	Angle LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)
Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	B30871

3.0	D21752	Angle RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)
Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	B31441

4.0	MS20470AD46	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 19.0000 Each(s)/Unit Total : 475.0000 Each(s)
Rivet, Universal Head

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	M103691

SAB 07/03/20 21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:57:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 30808

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

SB 07/03/30 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-30 21

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103706

M-R

07/03/30

(21x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SB 07/04/02 (2)

9.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 100.0000 Each(s)

Screw

Batch: M9216

X

10.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 100.0000 Each(s)

Washer

Batch: M103992

X

11.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 100.0000 Each(s)

Nut

Batch: M103538

X

SB 07/04/02 21

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

SB 07/04/02 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:57:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 30808

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2004-02

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/04/02 (21)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

RD 07/04/05

Job Completion



LE 07-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

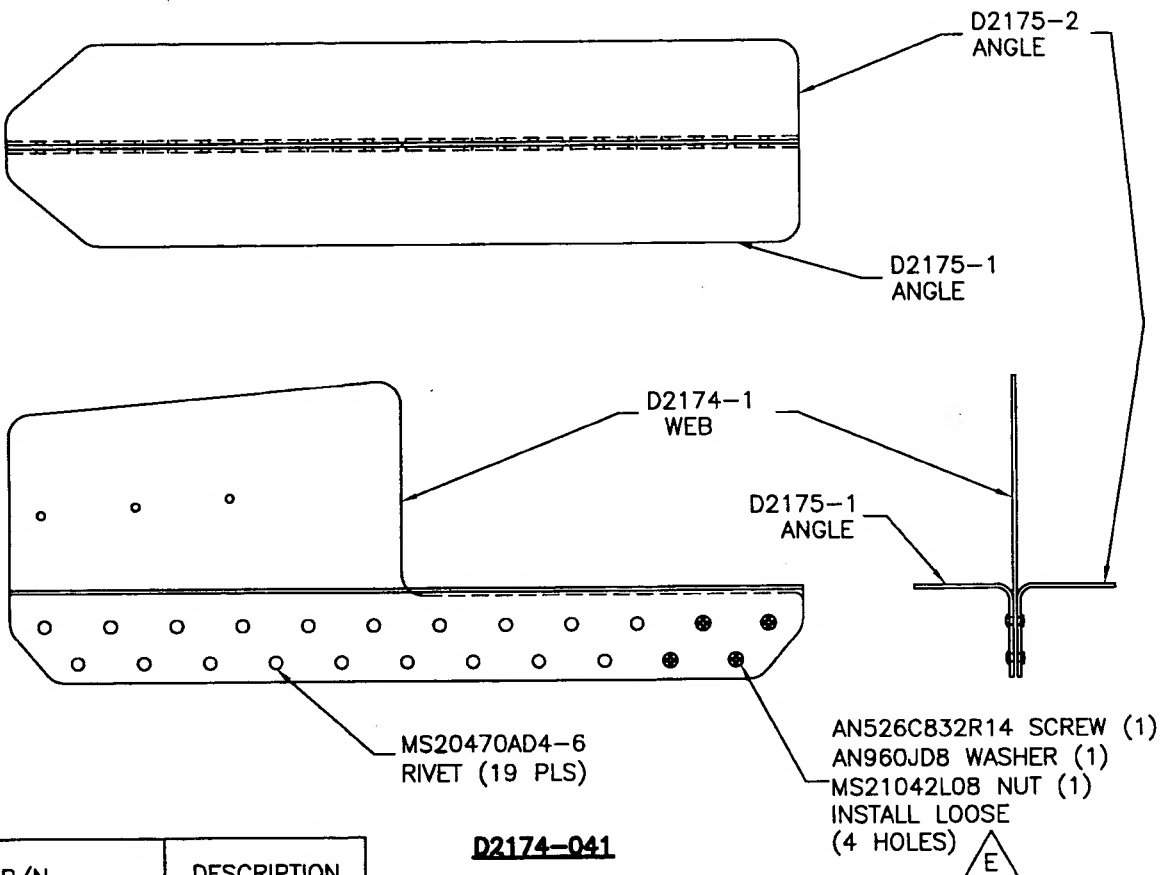
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED PH	APPROVED CH	DRAWING NO. D2174	REV. E
DATE 06.09.25		TITLE WEB ASSEMBLY	SHEET 1 OF 2
		SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 30808
WORK ORDER

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

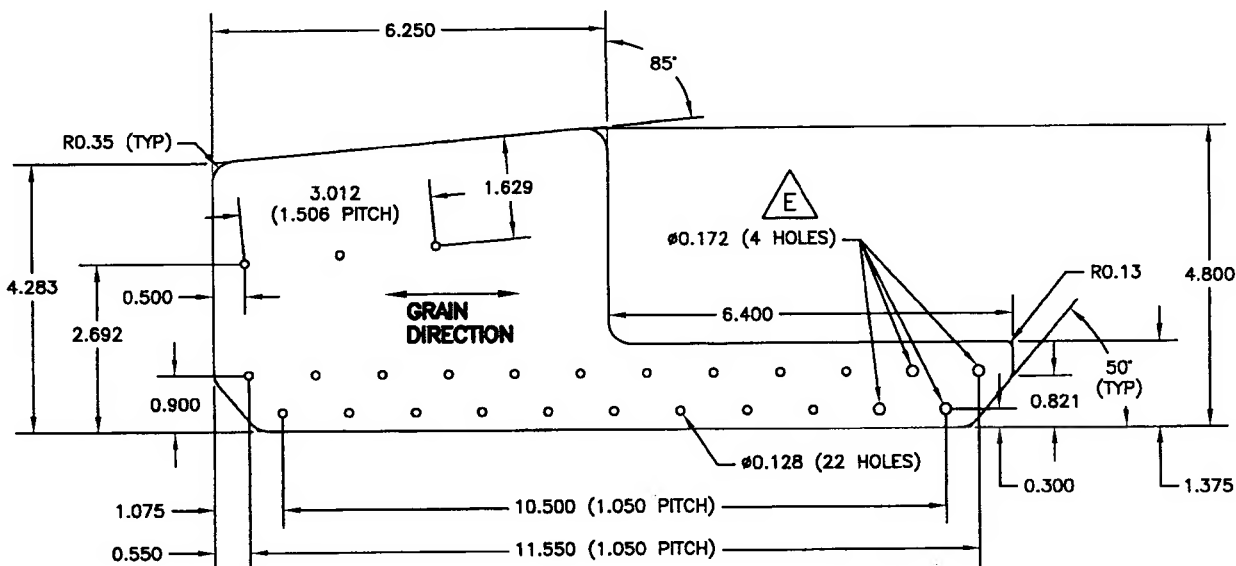
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13



DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.09.25	DRAWING NO.	D2174	REV. E
		TITLE	WEB	SHEET 2 OF 2
				SCALE 1:3

RELEASED
06.10.23



D2174-1

NOTES:

1. MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. BREAK ALL SHARP EDGES 0.005 TO 0.010
5. ALL DIMENSIONS ARE IN INCHES

WORK ORDER
NO. 30808
SUBJECT TO AMENDMENT
WITHOUT NOTICE